

SPLIT-01

SHIP NOV 29

Work Order ID 153186-1

Wednesday, November 09, 2016 12:41:37 P

153186

Page 1

Item ID: 647.1404

Revision ID:

Item Name: Upper Cutter Assembly

Start Date: 11/9/2016 Start Qty: 4.00

Required Date: 11/11/2016 Req'd Qty: 4.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: VS

Date: 10/11/9

Tooling:

Date:

Run Start

NR1

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

647.1400

B

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
6
9-89

DEC 16 2016

120

120

Small Fab

Memo

0.04

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: 135385
exp. date: 04/18DAS
36
9-89
12 16/12/14

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.01

Quality Control

DAS
38
9-89

DEC 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 153186

Wednesday, November 09, 2016 12:41:37 P

153186

Page 2

Item ID: 647.1404

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Upper Cutter Assembly

Start Date: 11/9/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/11/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: St

0.00

140

Packaging

Memo

0.01

***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND
REV***

Packaging

1
9-89
DEC 16 2016

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.07

Quality Control

DAS
21
9-89
DEC 16 2016
DEC 16 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

Picklist Print

Wednesday, November 09, 2016 12:41:45 PM

Page 1

Work Order ID: 153186

153186

Parent Item: 647.1404

647 1404

Parent Item Name: Upper Cutter Assembly

Start Date: 11/9/2016

Required Date: 11/11/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 16.03.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9703 *646 9703* Cutter Sub Assembly		Manufactured	No				Each	1.0000		4		NOV 16 2016	DAS 6 9-89

Location	Loc Qty	Loc Code
CCK013	1	

647.1513
647 1513
Upper Deflector

Manufactured No

Location	Loc Qty	Loc Code
148517	1	
	Each	3.0000

Location	Loc Qty	Loc Code
CCK015	3	

MS21042L08
MS21042L 08
Nut

Purchased No

Location	Loc Qty	Loc Code
146730	3	
	Each	1,060.000

Location	Loc Qty	Loc Code
GA	50	
m135274	50	
ST303	1010	
m135672	10	
m135766	200	
m135948	300	
m135978	500	

NOV 16 2016
DAS
6
9-89

NOV 16 2016
DAS
6
9-89

NOV 16 2016
DAS
6
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation			Disposition																		
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Root Cause			FAULT CATEGORY																		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER :																					

Picklist Print

Page 2

Wednesday, November 09, 2016 12:41:45 PM

Work Order ID: 153186

153186

Parent Item: 647.1404

647 1404

Parent Item Name: Upper Cutter Assembly

Start Date: 11/9/2016

Required Date: 11/11/2016

Start Qty: 4.00

Required Qty: 4.00

MS27039-08-19

Purchased

No

Each

315.0000

12

MS27039-08-19

NOV 16 2016

DAS
6
9-89

Screw

Location

Loc Qty

Loc Code

GA

182

m135948

182

ST277

133

m135865

33

m136042

100

Each

1,519.000

24

NAS1149FN832P

Purchased

No

NAS1149FN832P

NOV 16 2016

DAS
5
-89

Washer

Location

Loc Qty

Loc Code

GA

1389

M133769

89

M135058

1300

ST263

130

M135603

130

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

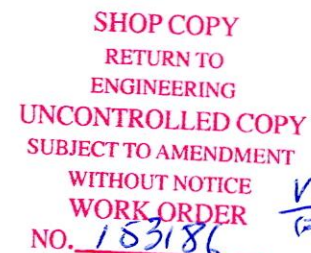
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. 346	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date : 346	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
346					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐						

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REV		DESCRIPTION	DATE	APPROVED
		LAST PROTOTYPE REVISION: PPT		N/C
N/C		INITIAL RELEASE	06/15/09	P. BRAVO
A		INCORPORATED ECN'S 02662 & 03911	06/07/13	P. BRAVO
B		INCORPORATED ECN'S 05330	02/28/16	P. BRAVO

1. IDENTIFY IAW MPP-120
2. APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 6, & 7 UPON ASSEMBLY



					10	647.1513	UPPER DEFLECTOR			
1					9	646.9703	CUTTER SUB ASSY			
	1				8	646.9702	CUTTER SUB ASSY			
		1			7	647.1501	LOWER DEFLECTOR ASSY			
	1		1		6	647.1510	UPPER DEFLECTOR			
A/R	A/R	A/R	A/R		5	601.2045	RTV, LOCITE 598			
3	3	3	3		4	601.1541	NUT	MS21042L08		
3	3	3	3		3	601.2765	SCREW	MS27039-0819		
6	6	6	6		2	601.2764	WASHER	NAS1149FN832P		
		1	1	1	646.9701	CUTTER SUB ASSY				
X					647.1404	CUTTER ASSY (UPPER)				
	X				647.1403	CUTTER ASSY (UPPER)				
		X			647.1402	CUTTER ASSY (LOWER)				
			X		647.1401	CUTTER ASSY (UPPER)				
1404	1403	1402	1401	FIND #	PART #	DESCRIPTION		MAT'L		SPEC
QTY						PARTS LIST				
NEXT ASSY (S)						ORIGINAL DATE 08-19-09 DRAWN BY CECHESTER 1 GLARDNER P. BIRAVO DRAWING APPROVAL P. BIRAVO 08-19-09 CONTRACT NO.				
647.1300						 DART 3030 ENTERPRISE CT. SUITE A VISTA, CA. 92081 (760)-724-5300 AEROSPACE AERIAL INDUSTRIES, INC. 030 DART AEROSPACE				
						CUTTER ASSY				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°						SIZE	CAGE CODE	DWG. NO.	REV.	
						B	07M26	647.1400	B	
						SCALE NONE			SHEET 1 OF 8	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ * Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																		
Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																		
Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																		
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																		
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																		
Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																		
Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																		
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																		
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																		
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																		
			OTHER : _____																																																																		